

Work Order ID 151950

Friday, October 14, 2016 1:55:54 PM

151950

Page 1

Item ID: D4131-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Side Plate

Start Date: 10/13/2016 Start Qty: 12.00

12

Cust Item ID:

Required Date: 10/14/2016 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: OCT 17 2016
QC: 9-89 Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4131	C
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100

0.00

100

Waterjet

Memo

0.14

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: CProg Rev: C

2-Deburr if necessary

(14)

as 16/10/22

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.02

Quality Control

(14)

as 16/10/22

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Accept

Setup Start *NS1*

Stop *NS2*

12

Cust Item ID:

Start Date: 10/13/2016 **Start Qty:** 12.00

12

Customer:

Required Date: 10/14/2016 **Req'd Qty:** 12.00

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

[illegible]

16/10/25

Picklist Print

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Page 1

Work Order ID: 151950

151950

Parent Item: D4131-5

D4131-5

Parent Item Name: Side Plate

Start Date: 10/13/2016

Required Date: 10/14/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 10.10.06 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased		No		100	sf	171.3240	0.0556	0.702316			

M304S18GA

304/316 .050 Sheet

OK 10/10/22

Location

Loc Qty

Loc Code

MAT020

65.9

M133328

55.224

M133587

0.7

M134824

20.4

M134982

20.2

M135779

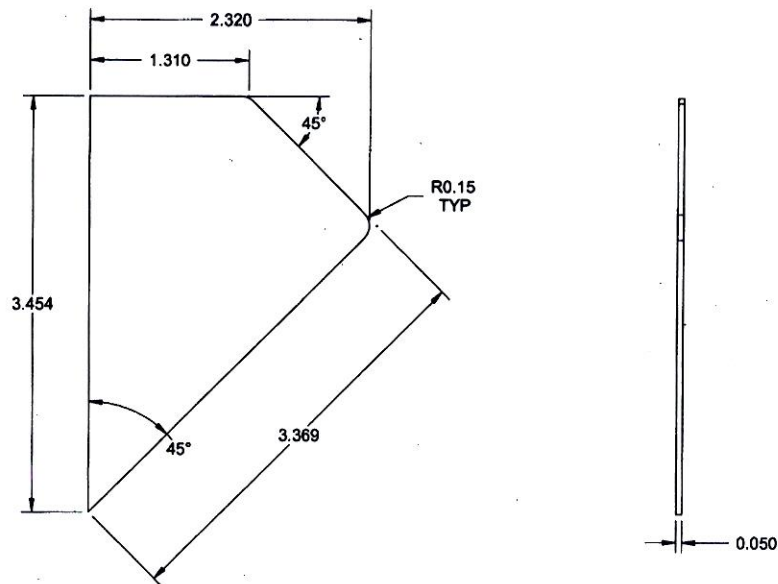
65.9

MAT20

8.9

M134580

8.9



D4131-5 SIDE PLATE

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.050 (18 GAUGE) SHEET
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
PER DART SPEC. M304S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151950 MJS
16-10-17

RELEASED
2014 -10- 20

APPROVED	DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
	DRAWN	RF		
	CHECKED	VS	DRAWING NO. D4131	REV. C
	MFG. APPR.	JFS	SHEET 8 OF 10	
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	MANIFOLD ASSEMBLY	NTS
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